



Designation: **A 351/A 351M – 003**

An American National Standard
Used in USDOE-NE Standards

Standard Specification for Castings, Austenitic, Austenitic-Ferritic (Duplex), for Pressure-Containing Parts¹

This standard is issued under the fixed designation A 351/A 351M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the Department of Defense.

¹ This specification is under the jurisdiction of ASTM Committee A01 on Steel, Stainless Steel, and Related Alloys and is the direct responsibility of Subcommittee A01.18 on Castings.

Current edition approved ~~Sept.~~ May 10, 2000³. Published ~~October 2000~~ June 2003. Originally published as ~~A 351–52 T~~, approved in 1952. Last previous edition ~~A 351/A 351M-94a (1999)~~, approved in 2000 as A 351/A 351M – 00.

1. Scope*

1.1 This specification² covers austenitic and austenitic-ferritic (duplex) steel castings for valves, flanges, fittings, and other pressure-containing parts (Note 1).

NOTE 1—Carbon steel castings for pressure-containing parts are covered by Specification A 216/A 216M, and low-alloy steel castings by Specification A 217/A 217M.

1.2 A number of grades of austenitic and austenitic-ferritic steel castings are included in this specification. Since these grades possess varying degrees of suitability for service at high temperatures or in corrosive environments, it is the responsibility of the purchaser to determine which grade shall be furnished. Selection will depend on design and service conditions, mechanical properties, and high-temperature or corrosion-resistant characteristics, or both.

1.2.1 Because of thermal instability, Grades CE20N, CF3A, CF3MA, and CF8A are not recommended for service at temperatures above 800°F [425°C].

1.2.2 Because of embrittlement phases, Grade CD4MCu is not recommended for service at temperatures above 600°F [316°C].

1.3 The values stated in either inch-pound units or SI units are to be regarded separately as standard. Within the text, the SI units are shown in brackets. The values stated in each system are not exact equivalents; therefore, each system must be used independently of the other. Combining values from the two systems may result in nonconformance with the specification.

2. Referenced Documents

2.1 ASTM Standards:

A 216/A 216M Specification for Steel Castings, Carbon, Suitable for Fusion Welding, for High-Temperature Service³

A 217/A 217M Specification for Steel Castings, Martensitic Stainless and Alloy, for Pressure-Containing Parts, Suitable for High-Temperature Service³

A 488/A 488M Practice for Steel Castings, Welding, Qualification of Procedures and Personnel³

A 703/A 703M Specification for Steel Castings, General Requirements, for Pressure-Containing Parts³

E 165 Test Method for Liquid Penetrant Examination⁴

E 709 Guide for Magnetic Particle Examination⁴

2.2 Manufacturers Standardization Society of the Valve and Fittings Industry Standard:

SP-55 Quality Standard for Steel Castings for Valves, Flanges, and Fittings and Other Components (Visual Method)⁵

3. General Conditions for Delivery

3.1 Material furnished to this specification shall conform to the requirements of Specification A 703/A 703M, including any supplementary requirements that are indicated in the purchase order. Failure to comply with the general requirements of Specification A 703/A 703M constitutes nonconformance with this specification. In case of conflict between the requirements of this specification and Specification A 703/A 703M, this specification shall prevail.

3.2 The post weld heat treatment requirements of Supplementary Requirement S11 may be specified when austenitic castings other than HK, HT, or CT15C are to be subjected to severe corrosive service.

4. Ordering Information

4.1 The inquiry and order should include or indicate the following:

4.1.1 A description of the casting by pattern number or drawing (dimensional tolerances shall be included on the casting drawing),

4.1.2 Grade of steel,

4.1.3 Options in the specification, and

4.1.4 Supplementary requirements desired, including the standards of acceptance.

5. Process

5.1 The steel shall be made by the electric furnace process with or without separate refining such as argon-oxygen decarburization (AOD).

6. Heat Treatment

6.1 All castings shall receive a heat treatment at the temperature specified in Table 1, followed by a quench in water or rapid cool by other means except as noted.

NOTE 2—Proper heat treatment of these alloys is usually necessary to enhance corrosion resistance and in some cases to meet mechanical properties. Minimum heat-treat temperatures are specified; however, it is sometimes necessary to heat-treat at higher temperatures, hold for some minimum time at

² For ASME Boiler and Pressure Vessel Code applications, see related Specification SA-351/SA-351M in Section II of that code.

³ Annual Book of ASTM Standards, Vol 01.02.

⁴ Annual Book of ASTM Standards, Vol 03.03.

⁵ Available from Manufacturers' Standardization Society of the Valve and Fittings Industry, 1815 N. Fort Myer Drive, Arlington, VA 22209.



TABLE 1 Heat-Treatment Requirements

| Grade | Temperature, min | |
|---|------------------|---------|
| | °F | °C |
| HK30, HK40, HT30, CT15C | as-cast | as-cast |
| CF3, CF3A, CF8, CF8A, CF3M, CF3MA, CF8M, CF3MN, CG3M, CF10, CF10M, CG8M, CD4MCu | 1900 | 1040 |
| CF10SMnN, CF8C, CF10MC | 1950 | 1065 |
| CD3MWCuN | 2010 | 1100 |
| CN7M, CG6MMN, CE8MN | 2050 | 1120 |
| CK3MCuN, CN3MN, CH8, CH10, CH20, CK20 | 2100 | 1150 |
| CE20N ^A | 2225 | 1220 |

^A Grade shall be quenched in water or the castings may be furnace cooled to 2050°F [1120°C] minimum, held for 15 min minimum and then quenched in water or rapidly cooled by other means.

temperature and then rapidly cool the castings in order to enhance the corrosion resistance and meet mechanical properties.

7. Chemical Composition

7.1 The steel shall conform to the requirements as to chemical composition prescribed in Table 2.

8. Tensile Properties

8.1 Steel used for the castings shall conform to the requirements as to tensile properties prescribed in Table 3.

9. Quality

9.1 The surface of the casting shall be examined visually and shall be free of adhering sand, scale, cracks, and hot tears. Other surface discontinuities shall meet the visual acceptance standards specified in the order. Visual Method SP 55 or other visual standards may be used to define acceptable surface discontinuities and finish. Unacceptable visual surface discontinuities shall be removed and their removal verified by visual examination of the resultant cavities.

9.2 When additional inspection is desired, Supplementary Requirements S5, S6, and S10 may be ordered.

9.3 The castings shall not be peened, plugged, or impregnated to stop leaks.

10. Repair by Welding

10.1 Repairs shall be made using procedures and welders qualified under Practice A 488/A 488M.

10.2 Weld repairs shall be inspected to the same quality standards that are used to inspect the castings. When castings are produced with Supplementary Requirement S5 specified, weld repairs on castings that have leaked on hydrostatic test, or on castings in which the depth of any cavity prepared for repair welding exceeds 20 % of the wall thickness or 1 in. [25 mm], whichever is smaller, or on castings in which any cavity prepared for welding is greater than approximately 10 in.²[65 cm²], shall be radiographed to the same standards that are used to inspect the castings. When castings are produced with Supplementary Requirement S6 specified, weld repairs shall be inspected by liquid penetrant examination to the same standards that are used to inspect the castings.

NOTE 3—When austenitic steel castings are to be used in services where they will be subject to stress corrosion, the purchaser should so indicate in his order and such castings should be solution-heat treated following all weld repairs.

11. Keywords

11.1 austenitic stainless steel; duplex stainless steel; pressure containing parts; stainless steel; steel castings

 **A 351/A 351M – 003**

TABLE 2 Chemical Requirements

NOTE 1—Tungsten is a new element for Table 2.

| Element, % (max, except where range is given) | CF3, CF3A J92700 | CF8, CF8A J92600 | CF3M, CF- 3MA J92800 | CF8M J92900 | CF3MN J92804 | CF8C J92710 | CF10 J92950 | CF- 10M 10M- {J92- 901} | CH8GH10 | GH20 | GK20 | HK30 | HK40 | HT30 | CF- J9340MG0 | CN |
|--|------------------------|------------------------|-------------------------------|----------------|-----------------|--------------------|-----------------|-------------------------------------|----------------|----------------|----------------|----------------|----------------|----------------|-----------------|----|
| Carbon | 0.03 0.25- 0.25- | 0.08 0.07 | 0.03 0.03 | 0.08 0.04 | 0.03 0.08 | 0.08 0.06 | 0.04- 0.08 | 0.04- 0.10 | 0.08 0.05- | 0.04- 0.025 | 0.04- 0.20 | 0.04- 0.03 | 0.04- 0.03 | 0.25- 0.03 | 0.35- | |
| Manganese | 0.10 1.50 | 0.10 1.50 | 1.50 | 0.10 1.50 | 0.20 1.50 | 0.20 1.50 | 0.35 1.50 | 0.45 1.50 | 0.35 1.50 | | | | | | | |
| Silicon | 2.00 2.00 | 1.50 1.50 | 1.50 | 2.00 2.00 | 1.00 1.00 | 1.00 1.00 | 4.00- 4.00- | 1.50 1.50 | 7.00- 7.00- | 0.15- 0.15- | 1.20 1.20 | 1.50 1.50 | 1.50 1.50 | 1.00 1.00 | | |
| Sulfur | | | | max | | | 6.00 | 0.040 | 9.00 | 1.50 | | | | | | |
| Phosphorus | 2.00 2.00 | 2.00 2.00 | 1.50 | 1.50 1.50 | 1.50 1.50 | 2.00 2.00 | 2.00 2.00 | 1.50 1.50 | 1.50 1.50 | 2.00 2.00 | 2.00 2.00 | 1.75 1.75 | 1.75 1.75 | 1.75 1.75 | | |
| Chromium | 0.040 0.040 | 0.040 0.040 | 0.040 0.040 | 0.040 0.010 | 0.040 0.04 | 0.040 0.040 | 0.040 0.030 | 0.040 0.04 | 0.040 0.030 | 0.040 0.03 | 0.040 0.010 | 0.040 0.040 | 0.040 0.04 | 0.040 0.025 | | |
| Nickel | 12.0 | 11.0 | 13.0 | 12.0 | 13.0 | 12.0 | 11.0 | 12.0 | 15.0 | 15.0 | 15.0 | 22.0 | 22.0 | 22.0 | | |
| Molybdenum | 0.040 | 0.040 | 0.040 | 0.040 | 0.040 | 0.040 | 0.040 | 0.040 | 0.040 | 0.040 | 0.040 | 0.040 | 0.040 | 0.040 | | |
| Columbium | 0.040 | 0.040 | 0.040 | 0.040 | 0.04 | 0.040 ^A | 0.040 | 0.04 | 0.060 | 0.03 | 0.045 | 0.040 | 0.04 | 0.030 | | |
| Vanadium | | | | max | | | | | | | | | | | | |
| Chromium | 17.0- 17.0- | 18.0- 18.0- | 17.0- 17.0- | 18.0- 18.0- | 17.0- 17.0- | 18.0- 18.0- | 18.0- 18.0- | 18.0- 18.0- | 22.0- 22.0- | 22.0- 22.0- | 22.0- 22.0- | 23.0- 23.0- | 23.0- 23.0- | 23.0- 23.0- | | |
| Nitrogen | 13.0- 21.0 | 15.0- 21.0 | 19.0- 21.0 | 20.0- 21.0 | 24.5- 21.0 | 22.5- 21.0 | 20.50- 21.0 | 18.0- 21.0 | 16.0- 26.0 | 19.0- 26.0 | 19.5- 26.0 | 23.0- 27.0 | 18.0- 27.0 | 24.0- 27.0 | | |
| Nickel | 8.0- 12.0 | 8.0- 11.0 | 9.0- 13.0 | 9.0- 12.0 | 9.0- 13.0 | 9.0- 12.0 | 8.0- 11.0 | 9.0- 12.0 | 12.0- 15.0 | 12.0- 15.0 | 12.0- 15.0 | 19.0- 22.0 | 19.0- 22.0 | 19.0- 22.0 | | |
| Copper | 8.0 | 8.0 | 9.0 | 9.0 | 9.0 | 9.0 | 8.0 | 9.0 | 12.0 | 12.0 | 12.0 | 19.0 | 19.0 | 19.0 | | |
| Tungsten | 33.0- 37.0 | 13.0- 16.0 | 27.5- 30.5 | 23.5- 26.5 | 4.75- 6.00 | 8.0- 11.0 | 11.50- 13.00 | 9.0- 13.0 | 8.0- 9.0 | 31.0- 34.0 | 17.5- 19.5 | 8.0- 11.0 | 9.0- 13.0 | 6.5- 8.5 | | |
| Molybdenum | 0.50 | 0.50 | 2.0 | 2.0 | 2.0 | 0.50 | 0.50 | 2.0 | 0.50 | 0.50 | 0.50 | 0.50 | 0.50 | 0.50 | | |
| Iron | 0.50 | 0.50 | 2.0 | 2.0 | 2.0 | 0.50 | 0.50 | 2.0 | 0.50 | 0.50 | 0.50 | 0.50 | 0.50 | 0.50 | | |

| Element, % (max, except where range is given) | HT30 N08030 | CF10MC | CN7M N08007 | CN3MN J94651 | CD- 4MCu J93370 | CE8MN | CG- 6MMN J93790 | CG8M J93000 | CF10S- MnN J92972 | CT15C N08151 | CK- 3MCuN J93254 | CE20N J92802 | CG3M J92999 | CD3M- WCuN ^B J93380 |
|--|----------------|----------------|---------------------|---------------------|-----------------------|--------------|-----------------------|---------------------|-------------------------|-----------------|------------------------|-----------------|----------------|--------------------------------------|
| Carbon | 0.50 | 1.75- 1.75- | 2.0- 2.0- 3.0 | 6.0- 6.0- 3.0 | 1.75- 1.75- 3.0 | 3.0- 3.0- | 1.50- 1.50- | 3.0- 3.0- 3.0 | ... | ... | 6.0- 6.0- | 0.50 | 3.0- 3.0- | 3.0- 3.0- |
| Manganese | 0.35 | | | 3.0 | | | | | | 0.15 | | | | |
| Manganese | 2.00 | 2.25 | 3.0 | 7.0 | 2.25 | 4.5 | 3.00 | 4.0 | 7.00 | 0.15 | 7.0 | 4.0 | 4.0 | |
| Columbium | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | |
| Silicon | ... | C | ... | ... | ... | ... | 0.40 | ... | ... | 0.50 | ... | ... | ... | |



A 351/A 351M – 003

| Element, % (max, except where range is given) | HT30 N08030 | CF10MC | CN7M N08007 | CN3MN J94651 | CD- 4MCu J93370 | CE8MN | CG- 6MMN J93790 | CG8M J93000 | CF10S- MnN J92972 | CT15C N08151 | CK- 3MCuN J93254 | CE20N J92802 | CG3M J92999 | CD3M- WCu ^B J93380 |
|--|----------------|--------------|----------------|-----------------|-----------------------|----------------------|-----------------------|----------------|-------------------------|-----------------|------------------------|-----------------|----------------|-------------------------------------|
| Silicon | ... | ... | ... | ... | ... | ... | 0.10– | ... | ... | 0.50– | ... | ... | ... | ... |
| (niobium) | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... |
| (niobium) | ... | ... | ... | max | ... | ... | ... | ... | 4.50 | 1.50 | ... | ... | ... | ... |
| Sulfur | 0.040 | 0.040 | 0.040 | 0.010 | 0.04 | 0.040 | –0.30 0.30 | 0.04 | 0.030 | 1.50 | ... | 0.040 | 0.04 | 0.025 |
| Sulfur | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... |
| Vanadium | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... |
| Phosphorus | ... | ... | ... | ... | ... | ... | 0.10– | ... | ... | ... | ... | ... | ... | ... |
| Chromium | ... | ... | ... | max | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... |
| Chromium | 13.0– | 15.0– | 19.0– | ... | 24.5– | ... | –0.30 0.30 | 18.0– | 16.0– | 19.0– | ... | ... | ... | ... |
| Chromium | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... |
| Nitrogen | ... | ... | ... | ... | –0.10 0.10– | ... | ... | ... | ... | ... | ... | ... | ... | ... |
| Nickel | ... | ... | ... | –0.18– | ... | –0.10– | –0.20– | ... | –0.08– | ... | –0.18– | –0.08– | ... | –0.20– |
| Nickel | ... | ... | ... | 0.18– | ... | 0.10– | 0.20– | ... | 0.08– | ... | 0.18– | 0.08– | ... | 0.20– |
| Nickel | 37.0 | 16.0 | 30.5 | 25.5 | 6.00 | 11.0 | 13.50 | 13.0 | 9.0 | 34.0 | 19.5 | 11.0 | 13.0 | 8.5 |
| Molybdenum | 0.50 | 1.75– | 2.0– | 6.0– | –0.20 0.20 | 3.0– | 1.50– | 3.0– | ... | ... | 6.0– | 0.50 | 3.0– | 3.0– |
| Molybdenum | ... | 2.25 | 3.0 | –0.26 0.26 | 2.25 | –0.30 0.30 | –0.40 0.40 | 4.0 | –0.18 | ... | –0.24 0.24 | –0.20 0.20 | 4.0 | –0.30 0.30 |
| Columbium | ... | ^c | ... | ... | ... | ... | 0.10– | ... | ... | 0.50– | ... | ... | ... | ... |
| (niobium) | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... |
| (niobium) | ... | ... | ... | ... | ... | ... | 0.30 | ... | ... | 1.50 | ... | ... | ... | ... |
| Copper | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... |
| Vanadium | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... |
| Vanadium | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... |
| Iron | ... | ... | ... | 3.0– | –0.75 4.0 | –2.75 max 3.25 | ... | ... | ... | ... | ... | –0.50– | –1.00 | ... |
| Iron | ... | ... | ... | 3.0– | 0.75 | 2.75– | ... | ... | ... | ... | ... | 0.50– | 1.00 | ... |
| Nitrogen | ... | 0.5– 1.0 | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... |
| Nitrogen | ... | 0.5– 1.0 | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... |
| Tungsten | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... |
| Tungsten | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | 0.24 | 0.20 | 0.30 |
| Copper | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | 0.5– 1.0 |
| Copper | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | 0.5– 1.0 |
| Iron | ... | ... | 4.0 | max | 3.25 | ... | ... | ... | ... | ... | 0.50– 1.00 | ... | ... | ... |
| Iron | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... |
| Tungsten | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | 1.0 |
| Iron | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | Bal | ... | ... |

^A % Cr + 3.3 % Mo + 16 % N ≥ 40.

^B Grade CF8C shall have a columbium content of not less than 8 times the carbon content but not over 1.00 %.

^C Grade CF10MC shall have a columbium content of not less than 10 times the carbon content but not over 1.20 %.

A 351/A 351M – 003

TABLE 3 Tensile Requirements

| | CF3 J92700 | CF-3A 3A J92700 | CF8 J92600 | CF-8A 8A J92600 | CF-3M 3M J92800 | CF-3MA 3MA J92800 | CF-8M 8M J92900 | CF-3MN 3MN J92804 | CF-8C 8C J92710 | CF10 J92950 | CF-10M 10M (J92-901) | CH8 J93400 | CH10 J93401 | CH20 J93402 | CK20 J94202 | HK30 J94203 | HK40 J94204 |
|---|---------------|-----------------------|---------------|-----------------------|-----------------------|-------------------------|-----------------------|-------------------------|-----------------------|----------------|----------------------------|-----------------|----------------|--------------------|----------------|----------------|----------------|
| HT30 | CF-10MG | CN-7M | CN-3MN | CD-4MCu | CE-8MN | CG-6MMN | CG-8M | CG10S-MnN | CT-15C | CK-3M-CuN | CE20N | CG-3M-(J92-999) | CG3M-WCuN | | | | |
| Tensile strength, | 70 | 77 | 70 | 77 | 70 | 80 | 70 | CG-8M | CG-15C | CK-3M-CuN | CE20N | CG-3M-(J92-999) | CG3M-WCuN | | | | |
| Tensile strength, min, ksi [MPa] | 70 | 77 | 70 | 77 | 70 | 80 | 70 | 75 | 70 | 70 | 70 | 95 | 85 | 75 | 85 | 63 | 80 |
| Yield strength, ^A min, ksi [MPa] | 65 | 70 | 70 | 65 | 65 | 62 | 65 | 70 | 62 | 80 | 100 | | | | | | |
| Yield strength, ^A min, ksi [MPa] | [485] | [530] | [485] | [530] | [485] | [550] | [485] | [515] | [485] | [485] | [485] | [450] | [485] | [485] | [550] | [515] | (700) |
| Yield strength, ^A min, ksi [MPa] | [450] | [450] | [425] | [450] | [485] | [425] | [550] | [690] | [655] | [585] | [515] | [585] | [435] | [550] | [550] | [515] | [700] |
| Yield strength, ^A min, % | -30 | -35 | -30 | -35 | -30 | -37 | -30 | -37 | -30 | -30 | -30 | -28 | -30 | -30 | -28 | -35 | -35 |
| Elongation in 2 in. or 50 mm, ^B min, % | 30 | 35 | 30 | 35 | 30 | 37 | 30 | 37 | 30 | 30 | 30 | 28 | 30 | 30 | 28 | 35 | 35 |
| Reduction of area, min, % | -28 | -30 | -25 | -38 | -70 | -65 | -42.5 | -35 | -42.5 | -25 | -38 | 40 | -35 | -65 min, ksi [MPa] | [205] | [240] | [205] |
| Reduction of area, min, % | 28 | 30 | 25 | 38 | 70 | 65 | 42.5 | 35 | 42.5 | 25 | 38 | 40 | 35 | 65 | [205] | [240] | [205] |

| | HT30 N08030 | CF-10MC | CN7M N08007 | CN-3MN J94651 | CD-4MCu J93370 | CE-8MN | CG-6MMN J93790 | CG8M J93000 | CF10S-MnN J92972 | CT15C N08151 | CK-3MCuN J93254 | CE20N J92802 | CG3M J92999 | CD3M-WCuN J93380 |
|---|----------------|-------------------|----------------|------------------|-------------------|--------|-------------------|----------------|---------------------|-----------------|--------------------|-----------------|----------------|---------------------|
| Tensile strength, min, ksi [MPa] | [240] | [205] | [255] | [205] | [255] | [205] | [205] | [205] | [195] | [205] | [205] | [195] | [240] | [240] |
| Elongation in 2 in. or 50 mm, ^B min, % | -35.0 | -35.0 | -35.0 | -35.0 | -30.0 | -30.0 | -30.0 | -35.0 | -30.0 | -35.0 | -30.0 | -30.0 | -30.0 | -30.0 |
| Yield strength, ^A min, ksi [MPa] | 35.0 | 35.0 | 35.0 | 35.0 | 30.0 | 30.0 | 30.0 | 35.0 | 30.0 | 35.0 | 30.0 | 30.0 | 30.0 | 30.0 |
| Yield strength, ^A min, % | -10.0 | -10.0 | -15.0 | -20.0 | -35.0 | -35 | -16.0 | -25.0 | -30.0 | -25.0 | -30.0 | -20.0 | -35 | -30.0 |
| Elongation in | 25 | 25.0 ^B | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... |
| Reduction of | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... | ... |

^A Determine by the 0.2% offset method.

^B When ICI test bars are used in tensile testing as provided for in Specification A 703/A 703M, the gage length to reduced section diameter ratio shall be 4 to 1.

SUPPLEMENTARY REQUIREMENTS

The following supplementary requirements shall not apply unless specified in the purchase order. A list of standardized supplementary requirements for use at the option of the purchaser is included in Specification A 703/A 703M. Those which are ordinarily considered suitable for use with this specification are given below. Others enumerated in Specification A 703/A 703M may be used with this specification upon agreement between the manufacturer and purchaser.

S2. Destruction Tests

S5. Radiographic Inspection

S6. Liquid Penetrant Inspection

S10. Examination of Weld Preparation

S10.1 The method of performing the magnetic particle or liquid penetrant test shall be in accordance with Practice E 165 or Practice E 709.

S11. Post Weld Heat Treatment

S11.1 All austenitic castings, except Grades HK, HT, and CT15C, which have been subjected to weld repairs, shall be given a post weld solution heat treatment.

SUMMARY OF CHANGES

Committee A01 has identified the location of selected changes to this standard since the last issue (A 351/A 351M – 00) that may impact the use of this standard.

(1) UNS numbers were added to Table 2 and Table 3.

ASTM International takes no position respecting the validity of any patent rights asserted in connection with any item mentioned in this standard. Users of this standard are expressly advised that determination of the validity of any such patent rights, and the risk of infringement of such rights, are entirely their own responsibility.

This standard is subject to revision at any time by the responsible technical committee and must be reviewed every five years and if not revised, either reapproved or withdrawn. Your comments are invited either for revision of this standard or for additional standards and should be addressed to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee, which you may attend. If you feel that your comments have not received a fair hearing you should make your views known to the ASTM Committee on Standards, at the address shown below.

This standard is copyrighted by ASTM International, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA 19428-2959, United States. Individual reprints (single or multiple copies) of this standard may be obtained by contacting ASTM at the above address or at 610-832-9585 (phone), 610-832-9555 (fax), or service@astm.org (e-mail); or through the ASTM website (www.astm.org).